

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018985**Date Inspected:** 31-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Liu Yang		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No
Component:	OBG	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Weld joint # 179, located on OBG Component, Floor beam stiffener to Longitudinal Diaphragm of Segment 13CW,P.P 125, SEG 3020W. Welder is identified as 067610. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B –P -2211 –TC-U4B-FCM-1.

Weld joint # 181, located on OBG Component, Floor beam stiffener to Longitudinal Diaphragm of Segment 13CW,P.P 125, SEG 3020W. Welder is identified as 047864. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B –P -2211 –TC-U4B-FCM-1.

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Weld joint # 005, located on OBG Component, Architectural House of Segment 13AW, AH 3001A. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – B –P -2213 –B –U3B.

Repair welding of Weld joint # 254 as per CWR no. B-CWR 2418, located on OBG Component, Deck plate of Segment 13CW, DP 3148-001. Welder is identified as 067707. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Repair welding of Weld joint # 024 as per CWR no. B-CWR 2411, located on OBG Component, Deck plate of Segment 13BW, DP 3135-001. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Flux cored Arc welding (FCAW)

Weld joint # 046, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 068445. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 028, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 052, located on OBG Component, Hinge plate to Bottom plate of of Segment 14W, SEG 3020D. Welder is identified as 202122. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

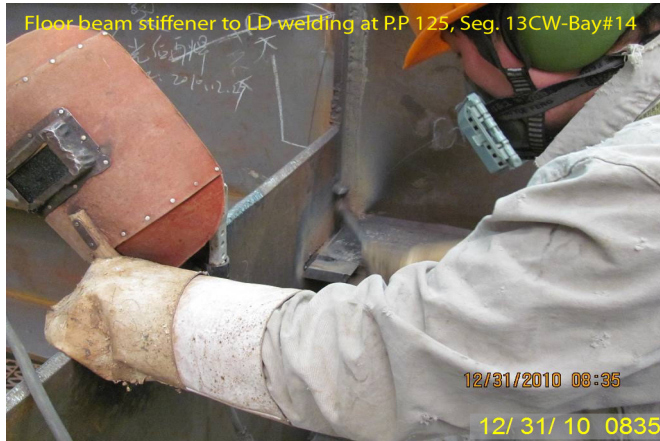
Weld joint # 056, located on OBG Component, Hinge plate to Bottom plate of of Segment 14W, SEG 3020D. Welder is identified as 066239. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer